

Date: Thursday, 4/12/2007 8:22:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 31661B	
Estimate Number : 10462	
P.O. Number : N/A	Part Number : D32782
This Issue : 4/12/2007 S.O. No. : N/A	Drawing Number : D3278 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 30563B	Material : N/A
Written By : <u> </u>	Due Date : 4/22/2007 Qty: 40 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est:A 04.04.19 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.2454 f(s)/Unit Total : 9.8154 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: M18745 X 22 PCS

M19295 X 18 PCS J.F. 07/04/23 (40)

2.0	SHEAR	SHEAR
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BAND SAW



Comment:

Cut blank: 2.00" x 1.00" x 2.550" long

J.F. 07/04/23 (40)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

J.L. 07/04/25 (P70)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. 07/04/25

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L. 07/04/25 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/03

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/25	3.0	30 parts were under size, at the 1.720" dimension → 1.705" + .005" under tolerance. Offset was off, operator error 10 parts are good.	J.L. 07/04/25	offset set corrected, making 10 parts to nominal. 30 parts at 1.705" → 1.710" are acceptable	J.L. 07/04/25		J.L. 07/04/25	J.L. 07/04/25

NOTE: Date & initial all entries

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Drawing Name: SUPPORT

Job Number: 31661B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

PX

07/04/26 (40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103706

HS

07-05-02 (40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 7/5/2 (40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5771*

P 7/5/02 (40)

(40)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/03 (40)

Job Completion



U 07-05-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31661B
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000					
0.359	+/-0.005					
0.615	+/-0.010					
0.250	+/-0.010					
1.480	+/-0.005					
R0.125	+/-0.010					
0.119	+0.005/-0.004					
2.439	+/-0.010					
1.980	+/-0.010					
R0.130	+/-0.010					
Ø0.257	+0.005/-0.000					
R0.375	+/-0.010					
0.875	+/-0.010					
0.500	+/-0.010					
R0.400	+/-0.010					
1.720	+/-0.010					
R0.125	+/-0.010					
0.125	+/-0.010					

Same as w/o 31736

Measured by:	J.L.	Audited by:	mf	Prototype Approval:	N/A
Date:	07/04/24	Date:	07/04/25	Date:	N/A

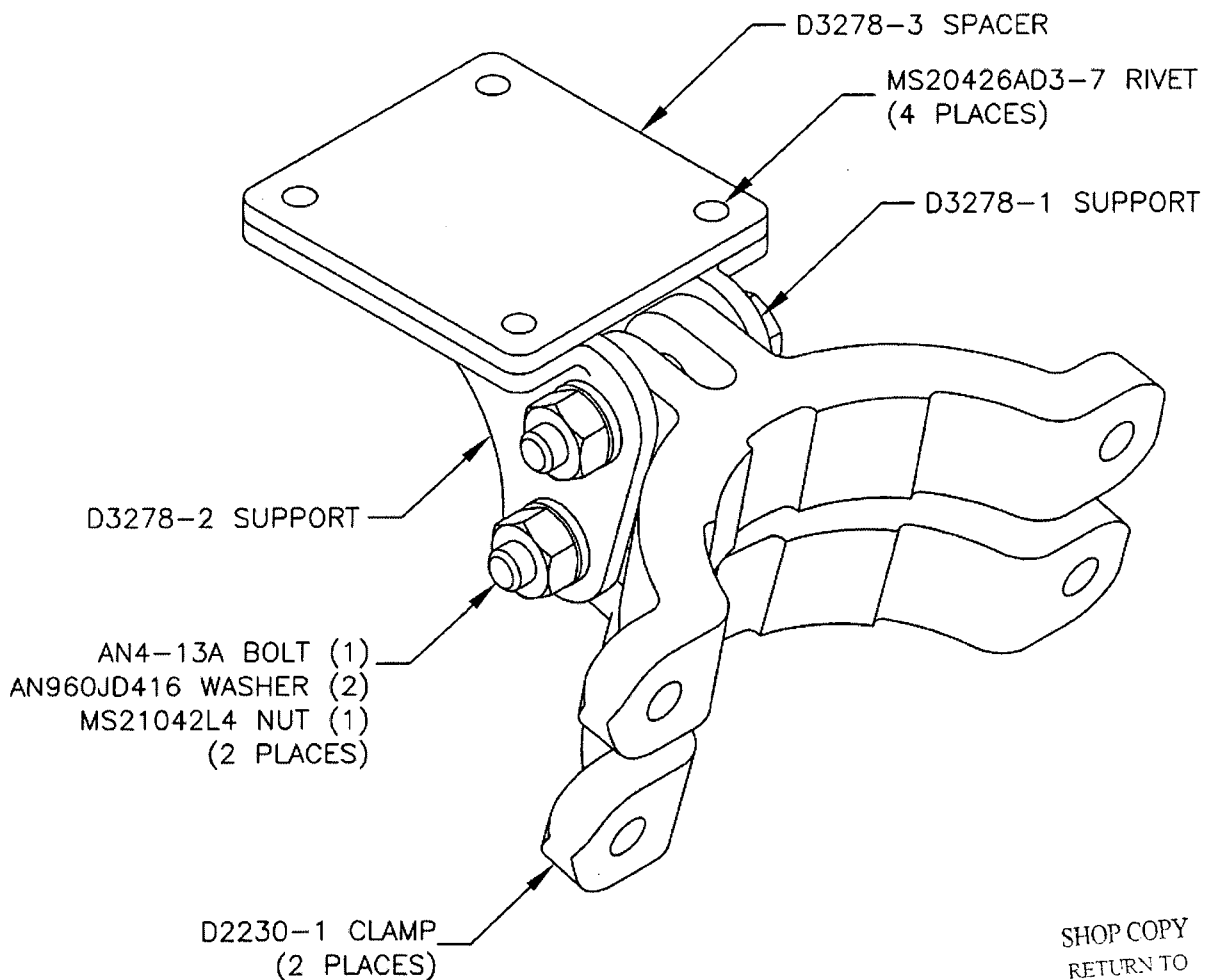
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	



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				D3278	SHEET 1 OF 3
DATE	05.03.31			TITLE	SCALE
				SUPPORT ASSEMBLY	NTS
A	04.03.03			NEW ISSUE	
B	05.03.31			CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04 *[Signature]*

D3278-041 SUPPORT ASSEMBLY



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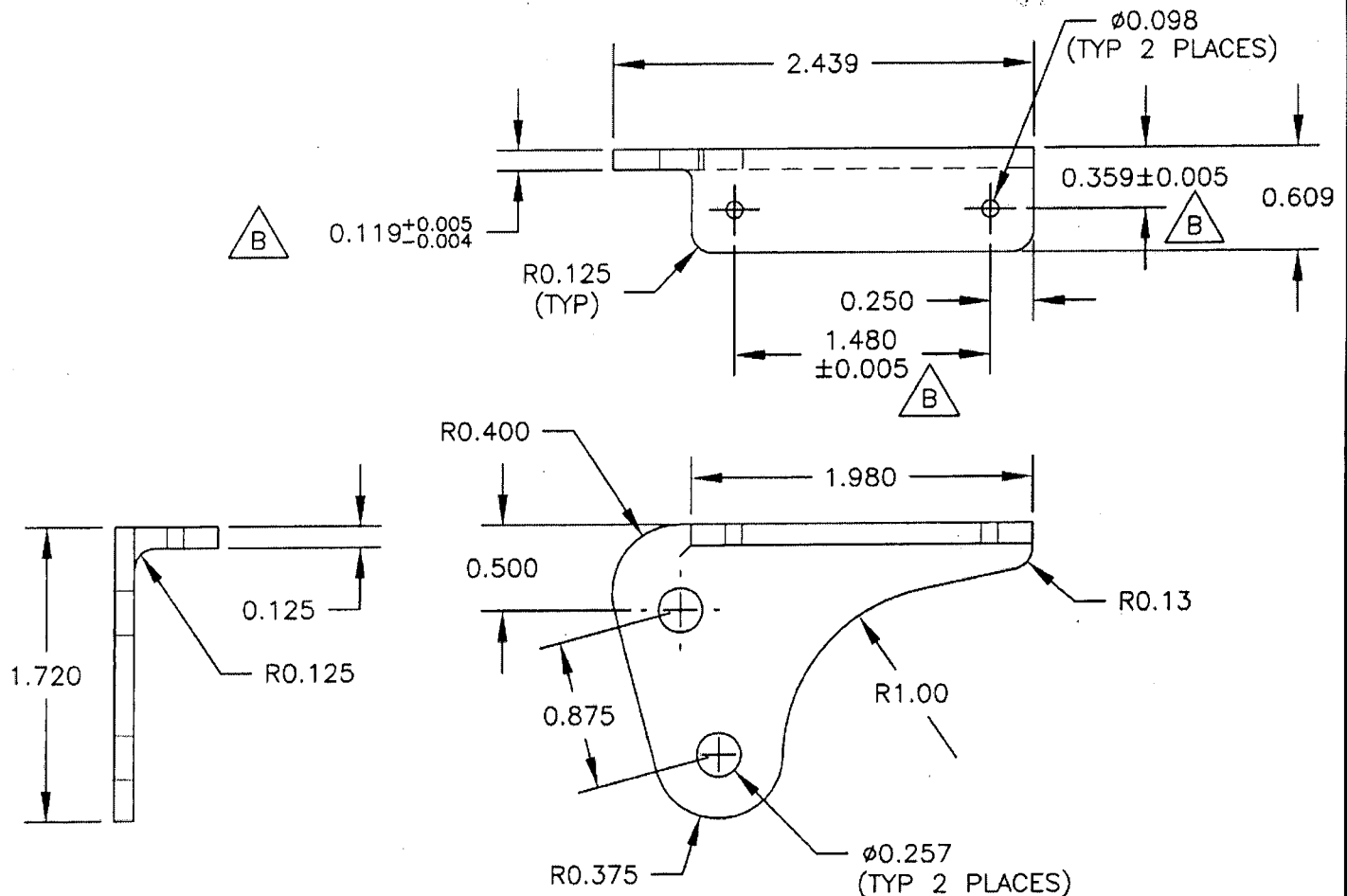
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

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05.04.04 *[Signature]*



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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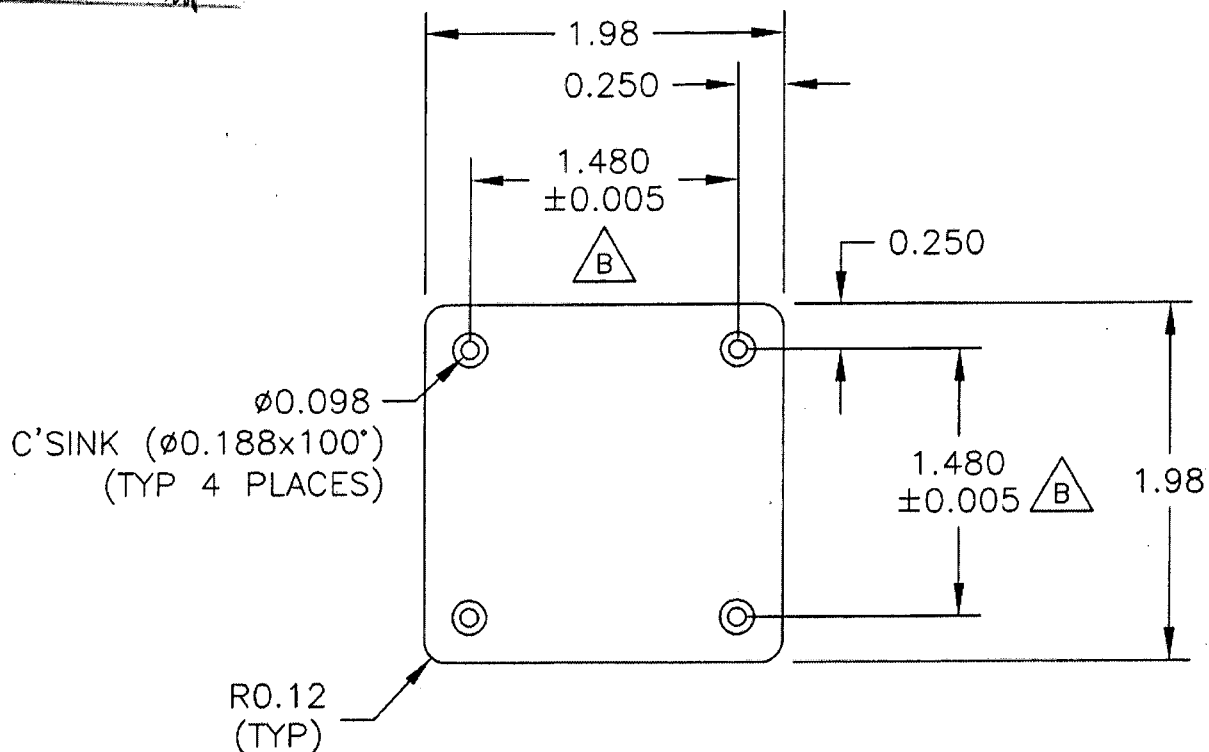
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
05.04.04 *[Signature]*



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B OR M-DELIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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